

Date: Monday, 7/9/2007 11:53:01 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 33396	
Estimate Number : 12764	
P.O. Number : N/A	Part Number : D35743
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D3574 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30999	Material : N/A
Written By : <u>JA 07.07.09</u>	Due Date : 7/13/2007 Qty: 3 Um: Each
Checked & Approved By : <u>JA 07.07.09</u>	
Comment : Est Rev: A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	F60029	lexan grey
-----	--------	------------



Comment: Qty.: 16.0000 sf(s)/Unit Total : 48.0000 sf(s)

F60029 lexan sheet

Batch: m103 106

HB 07-07-12

(3)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: AProg Rev: A

2-Deburr if necessary

HB 07-07-12

PHO →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-07-12

(3)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/07/13

(x2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

FF 07/07/13
 SAN 07/07/13


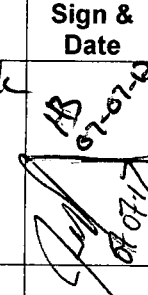
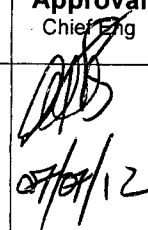
(3)

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/12	2	2 parts scrap. lead in and lead out found in parts R.C. Programming Error	 07/07/12	use further Destroy one and mark one for a template - Replace both. - Fix program	 07/07/12	En 07/07/12	 07/07/12	En 07/07/12

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:53:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 33396

Part Number: D35743

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/13 (24)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Per 7/13 (3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/13 (4)

Job Completion



07/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

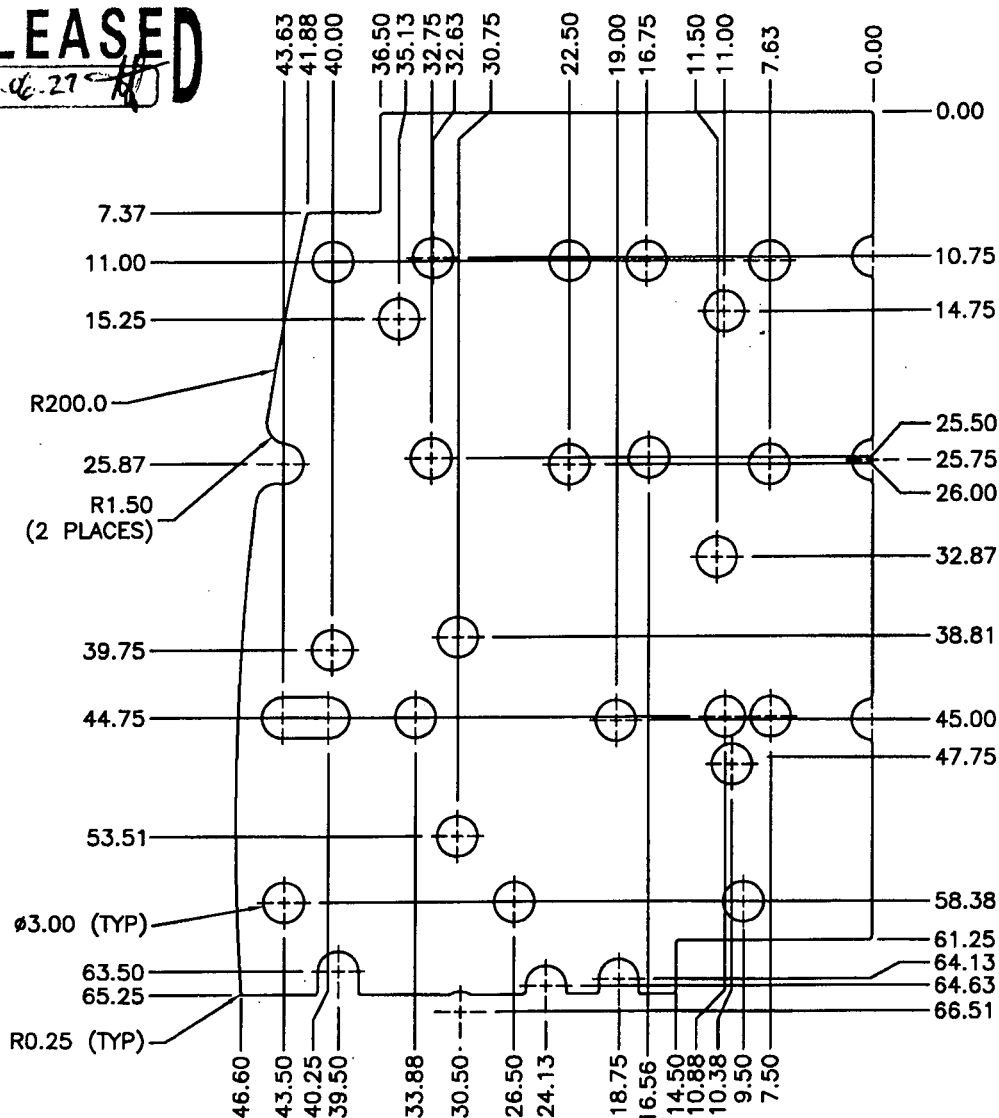
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27



D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO 33396

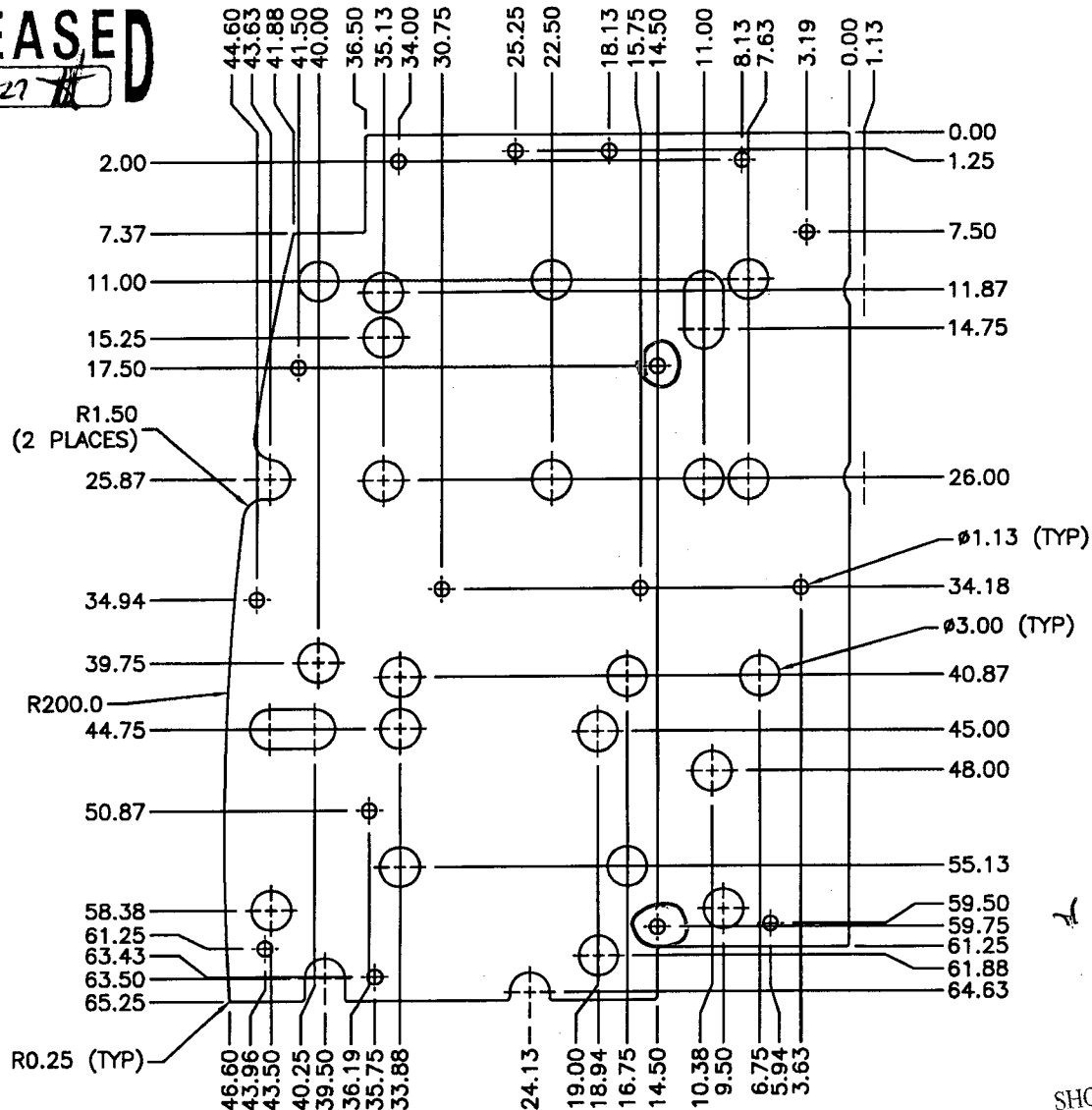
Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN LE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27



D3574-3 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33396
MARKER

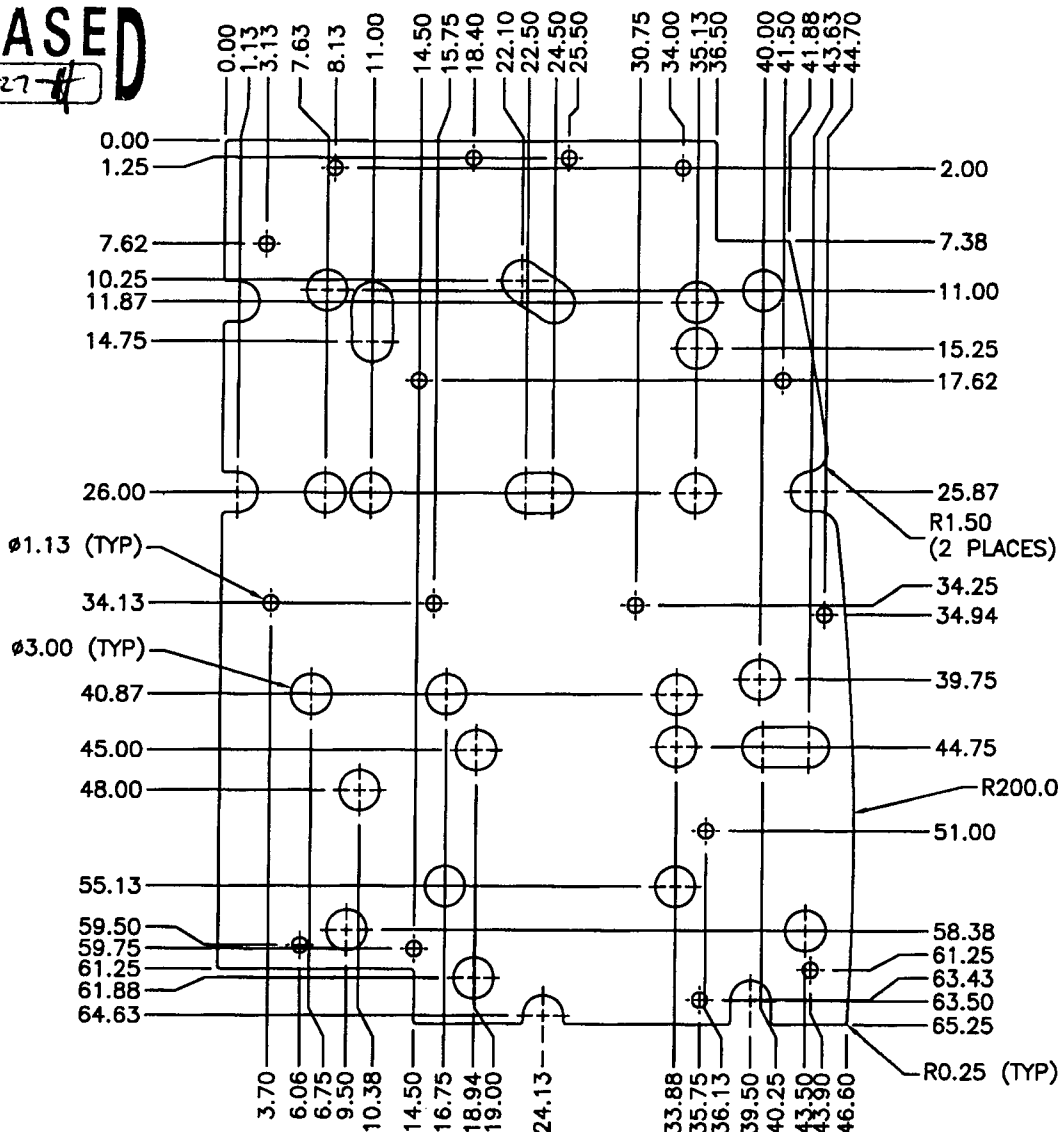
Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN LE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3574	REV. A SHEET 3 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27-#



D3574-4 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
33396
NO

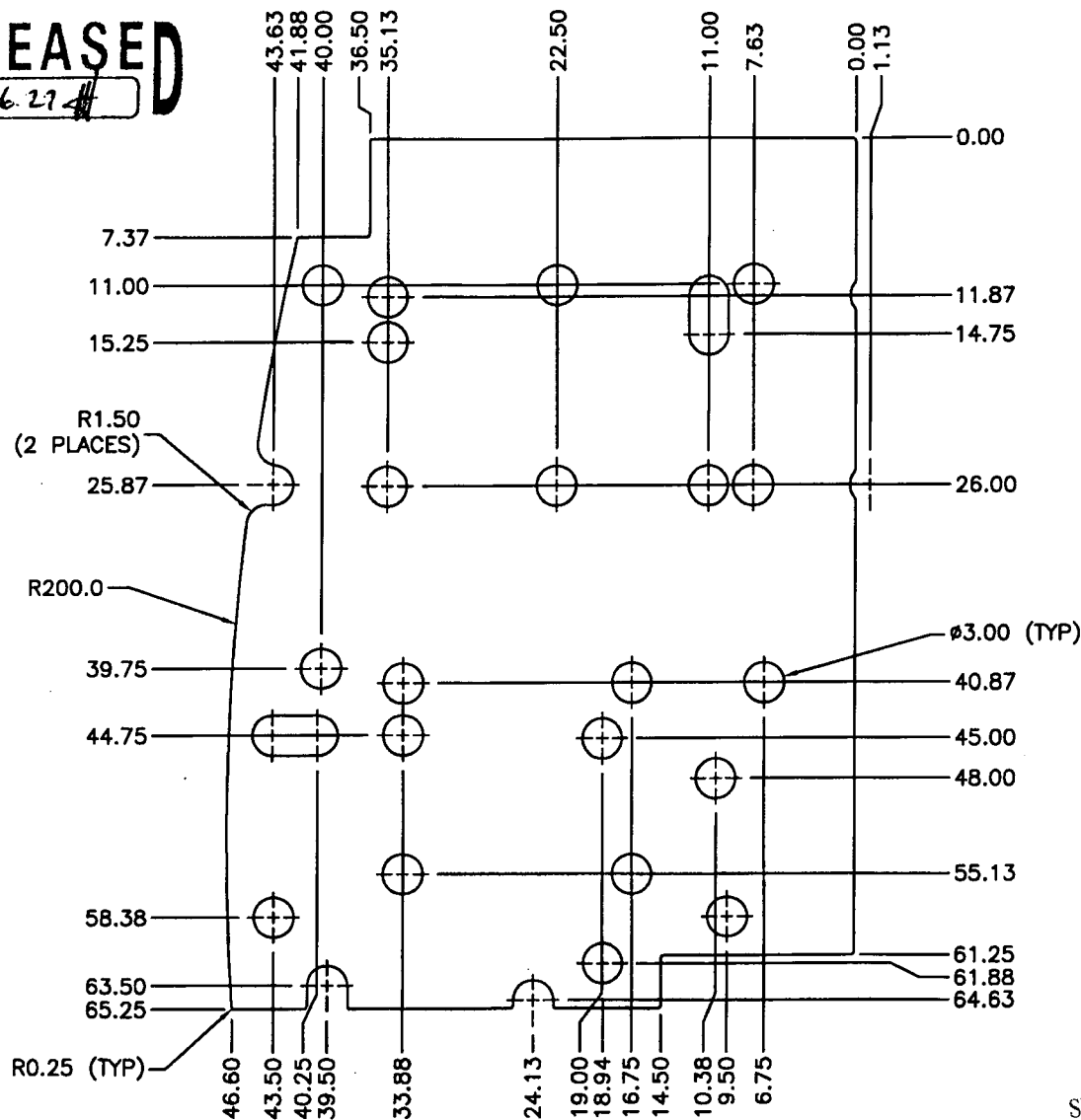
Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27



D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33396
MARKER

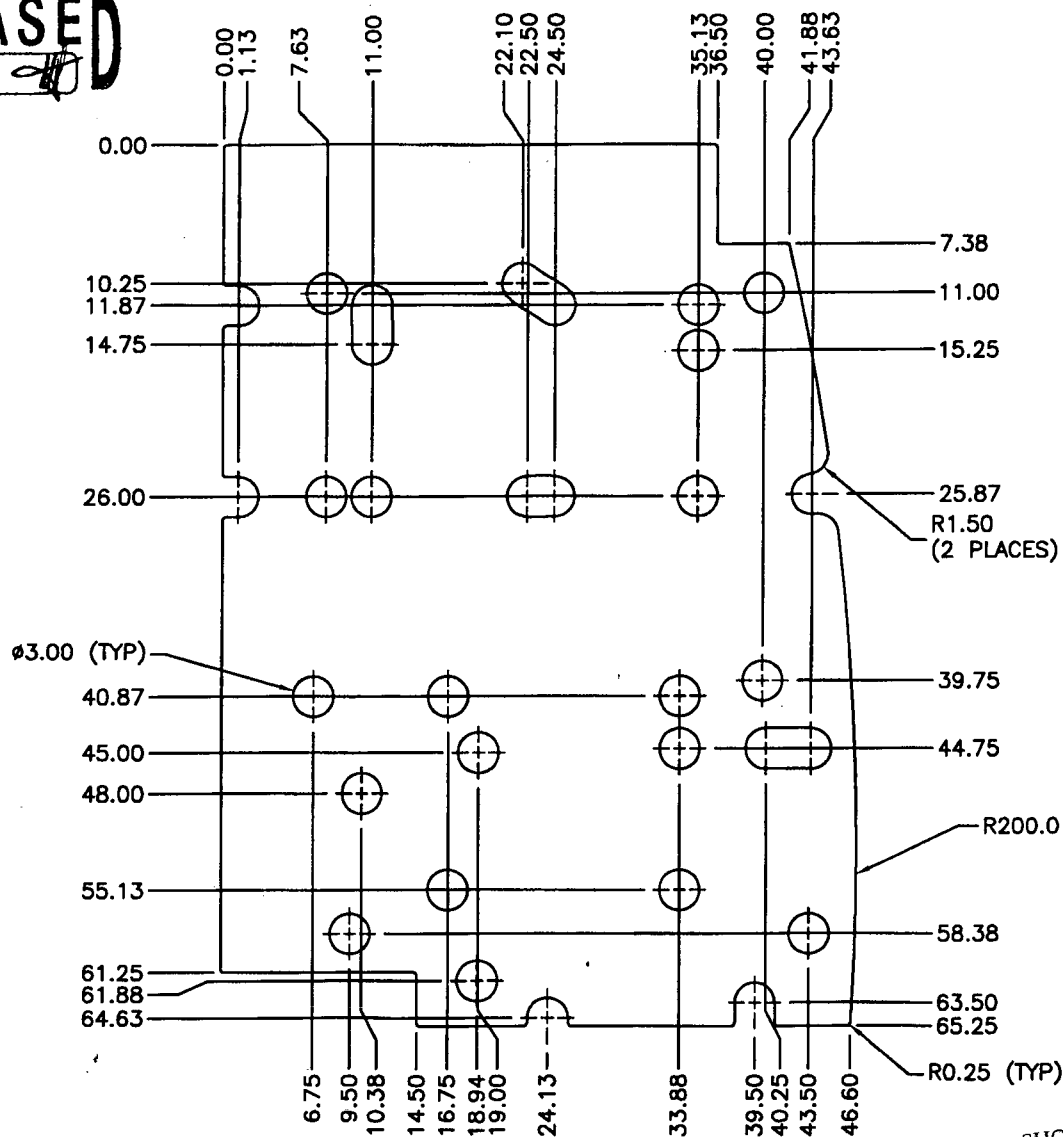
Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN LE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED 	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27



D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33396

Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 33396
Description: CABIN FLOOR PROTECTOR		Part Number: D 3574-3
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
44.60	+/- .030	44.60	*			
43.63	+/- .030	43.63	*			
41.88	+/- .030	41.88	*			
41.50	+/- .030	41.50	*			
40.00	+/- .030	40.00	*			
36.50	+/- .030	36.50	*			
35.13	+/- .030	35.13	*			
34.00	+/- .030	34.00	*			
30.75	+/- .030	30.75	*			
25.25	+/- .030	25.25	*			
22.50	+/- .030	22.50	*			
18.13	+/- .030	18.13	*			
15.75	+/- .030	15.75	*			
14.50	+/- .030	14.50	*			
11.00	+/- .030	11.00	*			
8.13	+/- .030	8.13	*			
7.63	+/- .030	7.63	*			
3.19	+/- .030	3.19	*			

Measured by: B	Audited by: En	Prototype Approval:
Date: 07-07-13	Date: 07/07/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

DART AEROSPACE LTD		Work Order: 33396
Description: CABIN FLOOR PROTECTOR		Part Number: D 3574-3
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46.60	+/- .030	46.60	*			
43.96	+/- .030	43.96	*			
43.50	+/- .030	43.50	*			
40.25	+/- .030	40.25	*			
39.50	+/- .030	39.50	*			
36.19	+/- .030	36.19	*			
35.75	+/- .030	35.75	*			
33.88	+/- .030	33.88	*			
24.13	+/- .030	24.13	*			
19.00	+/- .030	19.00	*			
18.94	+/- .030	18.94	*			
16.75	+/- .030	16.75	*			
14.50	+/- .030	14.50	*			
10.38	+/- .030	10.38	*			
9.50	+/- .030	9.50	*			
6.75	+/- .030	6.75	*			
5.94	+/- .030	5.94	*			
3.63	+/- .030	3.63	*			

Measured by: RB	Audited by: En	Prototype Approval:
Date: 07-07-12	Date: 07/07/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	